



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5549-013
Job Sheet 203213

Part No: D5549-013
Part Name: Aft Beam Assembly, LH

Job Qty: 1 pcs

POSITIVE RECALL
EFFECTIVE 12/12/19 **AUTH.** SAM
RELEASED **DATE**
Priority: Medium

Part Weight: 0 lbs
Job Created: 11/13/19
Due Date: 12/12/19
Type: SOLD

Status: New
Job Tracking No:
Created By: Marie Lajeunesse
Description:

Note: URF 19-880 D5549 REV.B IPP REV:A 17.09.05 NEW ISSUE DD VERF:DP IPP REV:B 18.01.17 AS PER DWG REV.B DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	1 pcs	12/12/19		0.00	0.58	Small Fab - 1		DAS 58 DEC 18 2019 9-89
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
							Small Fab - 8		
							Small Fab - 9		
120	QC 5	1 pcs	12/12/19		0.00	0.00	QC 5 - 10		DAS DEC 18 2019 40 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
130	Packaging 3-1 - Stock - B4B	1 pcs	12/12/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		

Plex 11/13/19 9:57 AM Dart.lajeunesse.marie

					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	P< ST476
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140 QC 21 - SA	1 pcs	12/12/19	0.00 0.00		QC 21 - SA - 21	
					QC 21 - SA - 70	DAS 21 DEC 20 2019
					QC 21 - SA - 53	

Part Op 110 - 1- Install and Manufacture D2690-13 lanyard, 2- Install D5553-1 with bolts and quick pin to Aft Beam. Torque nut as
Descriptions: per dwg. (see note 8) 3- Install D5550-043 to Aft Beam. Torque nut as per dwg.(see note 9)
120 - (QC5- Inspect part completeness to step on W/O)
130 - (Identify as per dwg & Stock Location: _____)
140 - (QC21- Final Inspection - Work Order Release)

013478

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
AN4-26A ST342	Bolt	10 Ea (10 ea)	110-Small Fab - 1	5183302
CBL-1240 GA115	Cable	2.8000 ft (2.8 ea)	110-Small Fab - 1	5198626
CBL-460 GA005	Loop Sleeve	4 Ea (4 ea)	110-Small Fab - 1	5187977
D5549-3	Aft Beam	1 pcs (1 ea)	110-Small Fab - 1	5237831
D5550-043	Aft Outboard Beam Assembly	1 pcs (1 ea)	110-Small Fab - 1	5240656
D5553-1	Bracket	2 pcs (2 ea)	110-Small Fab - 1	5237837
MS17984-C625 ST315	Pin, Quick Release	2 Ea (2 ea)	110-Small Fab - 1	5158303
MS20002C6 ST314	Washer	6 Ea (6 ea)	110-Small Fab - 1	5237818
MS21042L4 ST303	Nut	10 Ea (10 ea)	110-Small Fab - 1	5228617
MS21042L6 ST303	Nut	6 Ea (6 ea)	110-Small Fab - 1	5230553
MS21250-06026 ST305	Bolt	6 Ea (6 ea)	110-Small Fab - 1	5183323
NAS1149D0463J ST204	Washer	20 Ea (20 ea)	110-Small Fab - 1	5225595
NAS1149D0663J ST204	Washer	6 Ea (6 ea)	110-Small Fab - 1	5222693

5037738

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	AN4-26A	10	19	0
	CBL-1240	3	470	0
	CBL-460	4	313	0
	D5549-3	1	0	0
	D5550-043	1	0	0
	D5553-1	2	1	0
	MS17984-C625	2	10	0
	MS20002C6	6	20	0
	MS21042L4	10	5,583	0
	MS21042L6	6	75	0
	MS21250-06026	6	16	0
	NAS1149D0463J	20	7,348	0
	NAS1149D0663J	6	491	0
Part Specifications				
Specifications could not be found.				

Plex 11/13/19 9:57 AM Dart.lajeunesse.marie

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Water Jet ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier ☐ Quality ☐															
Date :	Sequence #:	QTY Affected :		MRB (QS1042)															
Description Work Order Deviation				Disposition															
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				FAULT CATEGORY															
				Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____				Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐				Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐				Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐			
												Completed by							
												Lead hand / Supervisor							
								QC / QA Coordinator											

Steven Drouin

From: David Shepherd
Sent: Thursday, November 28, 2019 6:49 PM
To: Steven Drouin
Subject: RE: D117 Basket

Steve,

I believe there is NO CHANGE to D5549-011 between D5549 Rev B and D5549 Rev C.
Therefore, it is OK to proceed with manufacturing D5549-011 to D5549 Rev B or D5549 Rev C.
Either drawing revision would be OK.

Regards,
David

From: Steven Drouin <sdrouin@dartaero.com>
Sent: November 28, 2019 4:11 PM
To: David Shepherd <dshepherd@dartaero.com>
Subject: D117 Basket

Hi David

Production is inquiring to make the following part D5549-011 to Rev. B for the D117-1044 basket for an order due on December 12th, but this is Under review (Ref URF19-880) the new Rev is not currently release, I think it's with FAA and we should get the approval by December 15th if I'm not mistaken.

My question would be could we make D5549-011 Rev. C for this order or should we wait for the approval from FAA and ECN to proceed 🙏

Thank you
Steven